

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization  
International Bureau



(43) International Publication Date  
25 October 2001 (25.10.2001)

PCT

(10) International Publication Number  
**WO 01/79398 A1**

- (51) International Patent Classification<sup>7</sup>: C10L 1/18, 1/22      (81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CR, CU, CZ, CZ (utility model), DE, DE (utility model), DK, DK (utility model), DM, DZ, EE, EE (utility model), ES, FI, FI (utility model), GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SK (utility model), SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.
- (21) International Application Number: PCT/US01/40509
- (22) International Filing Date: 12 April 2001 (12.04.2001)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:  
60/197,788      14 April 2000 (14.04.2000) US
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- (84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).

Published:

— with international search report

*For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.*

WO 01/79398 A1

(54) Title: ORGANIC CETANE IMPROVER

(57) Abstract: Embodiments of the invention described herein increase the amount of cetane in fuel. Cetane improvers comprising β-carotene, which was prepared in an inert atmosphere, as well as, methods of preparing such compositions are described. A preferred composition is a No. 2 diesel fuel comprising a cetane improver, which comprises a β-carotene that was prepared in an inert atmosphere.

**ORGANIC CETANE IMPROVER****FIELD OF THE INVENTION**

The present invention relates generally to a composition and method for increasing the amount of cetane in fuel. More specifically, it was discovered that the amount of cetane in fuel can be increased by mixing a fuel additive 5 comprising  $\beta$ -carotene that was prepared in an inert atmosphere.

**BACKGROUND OF THE INVENTION**

The interest in improving fuel efficiency has become paramount as our natural resources dwindle and the cost of fuel continues to rise. Fuel efficiency can be improved by adding a fuel additive. Several existing fuel additives are known to increase fuel efficiency, for example, U.S. Patent Nos. 4,274,835, 5,826,369, and 6,193,766 describe 10 fuel additives that improve combustion. Despite the successes of these inventions, there still remains a need for fuel additives that improve combustion.

**BRIEF SUMMARY OF THE INVENTION**

Embodiments of the invention described herein concern fuel additives that increase the amount of cetane in fuel and methods of use thereof. In one embodiment, for example, a method of improving the amount of cetane in a 15 fuel comprises the step of adding a  $\beta$ -carotene that was dissolved in an inert atmosphere to said fuel. In another embodiment, a cetane improver is made by providing  $\beta$ -carotene that was dissolved in an inert atmosphere, providing an alkyl nitrate, and mixing the  $\beta$ -carotene with the alkyl nitrate. In aspects of this later embodiment, the alkyl nitrate is 2-ethylhexyl nitrate or the inert atmosphere is nitrogen. Additionally, this later method of making a cetane improver can further comprise the step of mixing the  $\beta$ -carotene with toluene prior to mixing the  $\beta$ -carotene with the alkyl 20 nitrate.

Compositions of the invention can include, for example, a cetane improver made by one of the methods described above or a cetane improver comprising a non-oxygenated  $\beta$ -carotene. These cetane improver embodiments can also comprise an alkyl nitrate and/or a toluene. Additionally, in some compositions, the alkyl nitrate is 2-ethylhexyl nitrate. A preferred embodiment of the invention is a No. 2 diesel fuel comprising one of the cetane improvers 25 described above.

**DESCRIPTION OF THE INVENTION**

The invention described herein concerns a composition and method for increasing the amount of cetane in fuel. In one embodiment the cetane improver comprises  $\beta$ -carotene that was prepared under an inert atmosphere. Unexpectedly, it was discovered that  $\beta$ -carotene, which was dissolved in an inert atmosphere, raised the level of 30 cetane in No. 2 diesel fuel more effectively and maintained the raised cetane level longer than  $\beta$ -carotene prepared by conventional methods. In preferred embodiments, a cetane improver is prepared by mixing  $\beta$ -carotene that was dissolved in an inert atmosphere with a toluene carrier, and an alkyl nitrate (e.g., 2-ethylhexyl nitrate). The preferred cetane improver prepared by the methods described herein increased the level of cetane in No. 2 diesel fuel in a synergistic fashion.

In a preferred form, the cetane improver can be formulated by the following method. Under an inert atmosphere, (e.g., nitrogen, helium, or argon) four grams of  $\beta$ -carotene (1.6 million International units of vitamin A activity per gram) are dissolved in 3.785 liters of liquid hydrocarbon carrier toluene with heating and stirring.  $\beta$ -carotene dissolved or otherwise prepared under an inert atmosphere is referred to as "non-oxygenated  $\beta$ -carotene".

- 5 The mixture of non-oxygenated  $\beta$ -carotene and toluene is referred to as a "B/C-toluene solution". Approximately, 946 milliliters of the B/C-toluene solution is removed. Next, approximately 946 milliliters of a 100% solution of 2-ethylhexyl nitrate (also referred to as "2-EHN") is added to the 2.839 liters of B/C-toluene solution so as to obtain a total volume of 3.785 liters. That is, approximately 25% of the starting volume of B/C-toluene is removed and replaced by an equal volume of 2-ethylhexyl nitrate.

- 10 It should be understood that pure 2-EHN is desired but that variations in alkyl nitrates and in grade are also suitable. Further, one of skill will appreciate that other alkyl nitrates are equivalent to 2-EHN and can be substituted accordingly. Desirably, many different formulations of cetane improver are made, each having a different alkyl nitrate or more than one alkyl nitrate and/or proportions thereof relative to the  $\beta$ -carotene, which was dissolved under an inert atmosphere, and these formulations are evaluated for the ability to raise cetane levels in No. 2 diesel fuel according to  
15 the methods described below. In the embodiment described above, it is desirable to add the ingredients in the order described above. However, in other embodiments, variations in the order of addition can be made.

- The B/C-toluene-2-EHN solution is one embodiment of a "concentrated cetane improver," also referred to as "OR-CT." To improve the cetane level in No. 2 diesel fuel, approximately 0.1ml - 35ml of the concentrated cetane improver is added per one gallon of No. 2 diesel fuel. Preferably, the amount of concentrated cetane improver added to  
20 a gallon of No. 2 diesel fuel is, in the range from about 0.3 ml to about 30ml, more desirably, from about 0.5ml to about 25ml, still more preferably, from about 0.75ml to about 20ml, even more preferably, from about 1ml to about 15ml, and most preferably, from about 2ml to about 12ml. The Examples described below provide the results of tests performed according to the well accepted ASTM D-613 procedure on baseline fuels of various quality as measured by initial cetane levels. This data verifies that the cetane improver described herein synergistically improves the level of  
25 cetane in No. 2 diesel fuel.

#### EXAMPLE 1

<u>FORMULATION</u>	<u>CETANE LEVEL</u>
Baseline fuel No. 2 Diesel	40.5
No. 2 diesel with 1057 <sup>1</sup> ppm 2-EHN <sup>6</sup> only	44.98
No. 2 diesel with 1057 <sup>1</sup> ppm OR-CT <sup>3</sup> only	43.04
No. 2 diesel with 528.5 <sup>2</sup> ppm 2-EHN <sup>8</sup> + 528.5 <sup>2</sup> ppm OR-CT <sup>3</sup> mixed	45.39(+0.41)

WHAT IS CLAIMED IS:

1. A method of improving the amount of cetane in a fuel comprising the step of adding a  $\beta$ -carotene that was dissolved in an inert atmosphere to said fuel.
2. A method of making a cetane improver comprising:
  - 5 providing  $\beta$ -carotene that was dissolved in an inert atmosphere;
  - providing an alkyl nitrate; and
  - mixing the  $\beta$ -carotene with the alkyl nitrate.
3. The method of Claim 2, wherein the alkyl nitrate is 2-ethylhexyl nitrate.
4. The method of Claim 2, wherein the inert atmosphere is nitrogen.
- 10 5. The method of Claim 2, further comprising the step of mixing the  $\beta$ -carotene with toluene prior to mixing the  $\beta$ -carotene with the alkyl nitrate.
6. A cetane improver made by the method of Claim 2.
7. A cetane improver comprising a non-oxygenated  $\beta$ -carotene.
8. The cetane improver of Claim 7, further comprising an alkyl nitrate.
- 15 9. The cetane improver of Claim 7 or 8, further comprising a toluene.
10. The cetane improver of Claim 8 or 9, wherein the alkyl nitrate is 2-ethylhexyl nitrate.
11. A No. 2 diesel fuel comprising the cetane improver of Claim 7.

## INTERNATIONAL SEARCH REPORT

International application No.  
PCT/US01/40509

<b>A. CLASSIFICATION OF SUBJECT MATTER</b>		
IPC(7) : C10L 1/18, 1/22 US CL : 44/307,323 According to International Patent Classification (IPC) or to both national classification and IPC		
<b>B. FIELDS SEARCHED</b>		
Minimum documentation searched (classification system followed by classification symbols)  U.S. : 44/307,323		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)  WEST(beta aj carotene, diesel adj fuel, inert adj atmosphere, nitrate, ethylhexyl adj nitrate, carotene adj toluene)		
<b>C. DOCUMENTS CONSIDERED TO BE RELEVANT</b>		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 4,274,835 A (JORDAN) 23 June 1981, abstract col. 1, line 53 to col. 2, lines 1-6 and 12 to col. 3, lines 1-25 and claims 3 and 5.	1-11
Y	US 2,582,192 A (DENISON, JR.) 08 January 1952, col. 1, 27-37.	2-6 and 8-10
Y	US 4,208,190 A (MALEC) 17 June 1980, abstract ,col. 2, lines 26-36 and 53.	2-6 and 8-10
Y	US 5,826,369 A (JORDAN) 27 October 1998, abstract, col. 2, line 61 to col .3, lines 13and claims 1-17.	1-11
Y,P	US 6,193,766 B1 (JORDAN) 27 February 2001, abstract, col. 3, lines 15-40 and claims 1-11.	2-6 and 8-10
<input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C. <input type="checkbox"/> See patent family annex.		
* Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier document published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed		
Date of the actual completion of the international search  26 JUNE 2001		Date of mailing of the international search report  26 JUL 2001
Name and mailing address of the ISA/US Commission of Patents and Trademarks Box PCT Washington, D.C. 20231 Facsimile No. (703) 305-3230		Authorized officer  MARGARET B. MEDLEY DEBORAH THOMAS PARALEGAL SPECIALIST Telephone No. (703) 308-2518

**INTERNATIONAL SEARCH REPORT**International application No.  
PCT/US01/40509**C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT**

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	EP 0,457,589 A1 (CUNNINGHAM et al) 21 November 1991, abstract, page 4, lines 5-55 and 35, and claims 1-10.	2-6 and 8-10